

# Work Order ID 72426

Monday, July 25, 2011 1:46:05 PM

Page 1

Item ID: D3315-5

Revision ID:

Item Name: Wearplate

Start Date: 7/25/2011 Start Qty: 2.00

Required Date: 7/26/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

0.00

11/07/25

2

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

11/07/25

2

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

11 07 26 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives of the project. These objectives should be clear, measurable, and achievable.

3. The third step is to develop a plan of action. This involves determining the steps that need to be taken to achieve the objectives and assigning responsibilities to team members.

4. The fourth step is to implement the plan. This involves carrying out the tasks and activities that have been planned.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and identifying any areas for improvement.

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. Next, it is important to gather relevant information and data. This can be done through research, consultation with experts, or by analyzing existing data sets.

3. Once the information is gathered, the next step is to analyze it. This involves identifying patterns, trends, and potential solutions. It is important to consider all relevant factors and to evaluate the feasibility of different options.

4. After analysis, the next step is to develop a plan or strategy. This involves determining the most effective way to address the problem or question, taking into account the available resources and the potential risks.

5. Finally, the plan is implemented. This involves putting the strategy into action and monitoring the progress. It is important to be flexible and to adjust the plan as needed based on the results.

**Cust Item ID:**

\_\_\_\_\_

**Customer:**

**Reference:**

Run Start

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

### Tool ID

Tool #

**Plan  
Code**

**Accept Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

0.00

\_\_\_\_\_

NC BRAKE

0.00

Brake NC

## Memo

1- Form using DT8751 Die as per Dwg D3315Rev:

2- Form using DT8179 Die as per Dwg D3315Rev:

0.00

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

QC6- Inspect dimensions to drawing

0.00

QC

## Memo

## Quality Control

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

## Large Fab

0.00

Large Fab

## Memo

Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: B

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

A/R	N/A	7560 Hardcoat Rod
-----	-----	-------------------

M117139

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72426

Monday, July 25, 2011 1:46:06 PM



Page 3

Item ID: D3315-5	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearplate					
Start Date: 7/25/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 7/26/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							11.07.26 (2)
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							11.07.26 (2)
180 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo START TIME: 1:45. OVEN TEMPERATURE: 300° FINISH TIME: 2:15.	0.00							2 BL 11-7-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 72426**

Monday, July 25, 2011 1:46:06 PM



Page 4

Item ID: D3315-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 0 11/10/26

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-5, B/N: BXXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 496A

11/7/26 20 0

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/26 0

11-07-26 0

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, July 25, 2011 1:46:13 PM

Page 1

Work Order ID: 72426

Parent Item: D3315-5

Parent Item Name: Wearplate




Start Date: 7/25/2011

Required Date: 7/26/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A 05.05.12 New issue KJ/JLM  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 		Purchased	No			100	sf	150.5000	1.8345	3.862105			
1010/1025 sheet 16GA													

Location

Loc Qty

Loc Code

MAT019

150.5

116791

32.5

117500

118

4.0 ~~9.0~~ 11/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


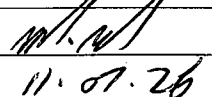
**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	72424
Description: Wearplate		Part Number:	D3315-5
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	✓		RA04	TARE
30.215	+/-0.010	30.215	✓		"	
24.215	+/-0.010	24.220	✓		"	
21.611	+/-0.010	21.615	✓		"	
17.965	+/-0.010	17.970	✓		"	
16.026	+/-0.010	16.030	✓		"	
14.735	+/-0.010	14.735	✓		"	
12.815	+/-0.010	12.817	✓		"	
6.465	+/-0.010	6.465	✓		RA04	TARE
5.464	+/-0.010	5.464	✓		RA26	Jern
4.527	+/-0.010	4.530	✓		"	
3.550	+/-0.010	3.560	✓		"	
5.214	+/-0.010	5.211	✓		"	
Ø0.300	+0.006/-0.001	.301	✓		"	
Ø0.266 x 0.575	+/-0.010	267x.577	✓		"	
Ø0.266 x 0.450	+/-0.010	268x.453	✓		"	Jern

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/07/25	Date: 11.07.26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

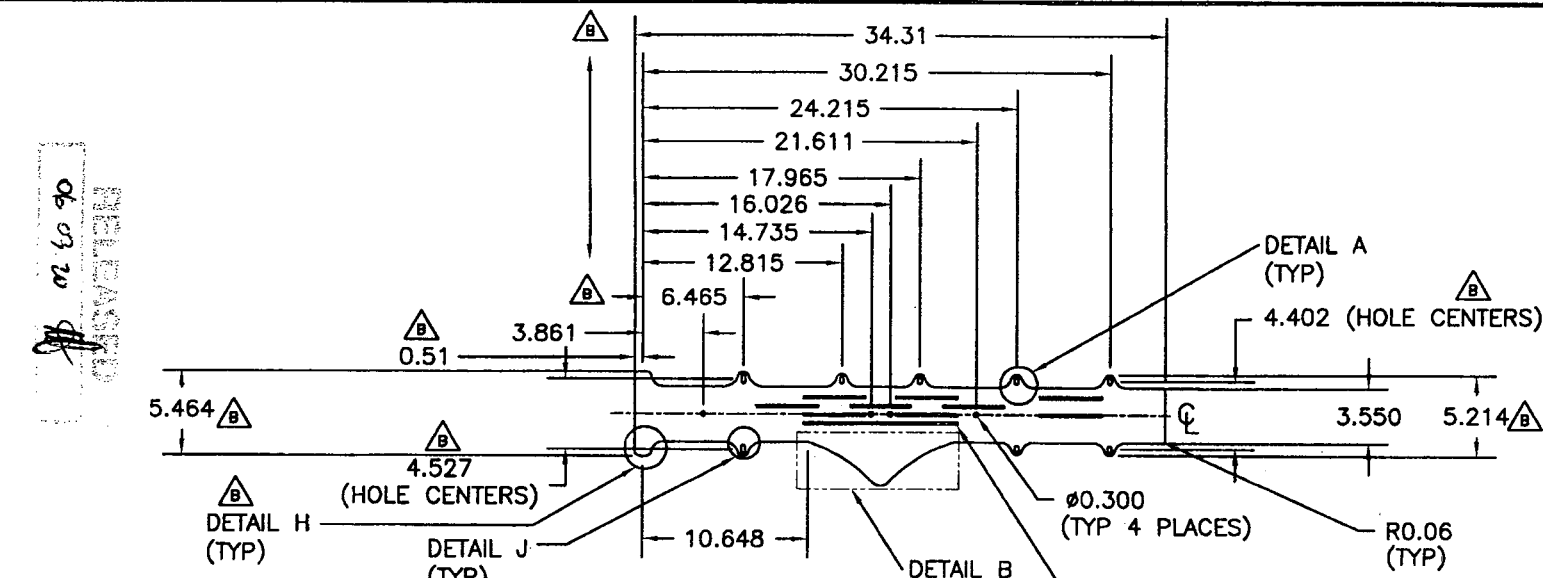
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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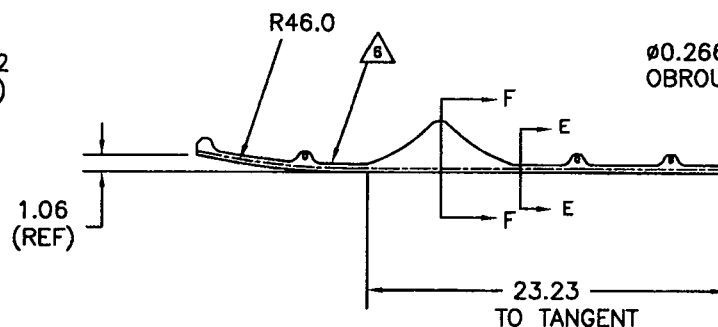
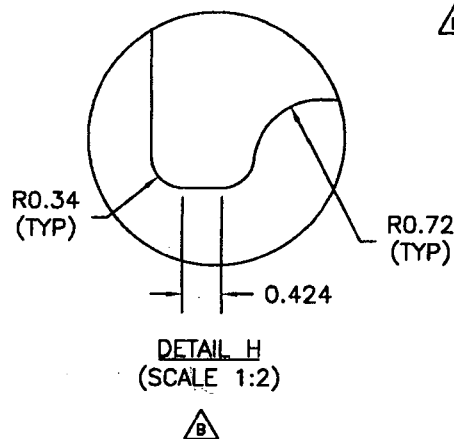
**NOTE:** Date & initial all entries

**DART**

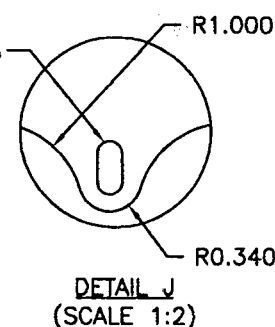


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. B
DATE	06.01.31	TITLE	D3315	SHEET 3 OF 4
		WEARPLATE		SCALE 1:12

06.03.20  
RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries